

**Amendments to the Claims:**

The listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

**Claim 1 (currently amended):** A method for ~~the production of producing~~ a vehicle component, ~~particularly a chassis frame (1), which is equipped with~~ ~~includes~~ spring strut mountings, ~~(44)~~, of an off road vehicle, ~~in which elongate[[],]~~; ~~wherein:~~

~~horizontally disposed spaced apart parallel elongate tubular longitudinal member hollow profiles (2, 3, 39, 40), which run parallel and are spaced apart from one another in the horizontal plane, are connected nonreleasably to one another at [[the]] respective longitudinal member end ends thereof, by tubular cross member hollow profiles; (4, 41),~~

~~in which a hollow-profile-like crossbar [(5)] for receiving a rear axle, a differential and a transverse link, and a hollow-profile-like crossbar [(15)], which is spaced apart in the longitudinal direction and is intended for the securing of adapted to secure a vehicle transmission between the two end-side cross member hollow profiles (4, 41), are secured on the longitudinal member hollow profiles; (2, 3, 39, 40),~~

~~in which the size and shape of the cross section of the longitudinal member hollow profiles (2, 3, 39, 40) are formed in an expanding manner by means of internal high pressure forming[[],];~~

~~in which body mountings (6, 7, 24, 42) of the frame [(1)] are formed by forming secondary shaped elements laterally from the longitudinal member hollow profile (2, 3, 39, 40) by means of exertion of application a fluidic internal~~

high pressure and subsequent vertical perforation of the secondary shaped elements, ~~in which the~~:

unperforated secondary shaped elements, which contain ~~the side~~ an edge [[(22)]] of the upper side [[(23)]] of the respective longitudinal member hollow profile ~~(2, 3, 39, 40)~~, ~~are, after they are formed,~~ and are thereafter pinched flat [[with]] such that a radially protruding sheet-metal fold ~~(25)~~ being is formed[[.]]; and

~~in which~~ bearing mountings ~~(19, 43)~~ of longitudinal links are likewise formed, as secondary shaped elements, laterally outward from the longitudinal member hollow profile ~~(2, 3, 39, 40)~~ by ~~means of~~ fluidic internal high pressure, and are subsequently perforated.

**Claim 2 (currently amended):** The method as claimed in claim 1, ~~characterized in that wherein~~ the body mounting ~~(6, 7, 24, 42)~~ is pinched flat in an internal high pressure forming die by closing the die with the radially protruding sheet-metal fold [[(25)]] being formed.

**Claim 3 (currently amended):** The method as claimed in ~~either of~~ claims 1 and 2, ~~characterized in that the perforations of~~ claim 1, wherein the body mountings, ~~(6, 7, 24, 42)~~, of the bearing mountings, ~~(19, 43)~~ of the longitudinal links, and [[of]] the spring strut mountings ~~(44)~~ ~~take place by means of~~ are perforated by hole punches which are integrated into [[the]] an internal high pressure forming die, in which the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are formed by internal high pressure.

**Claim 4 (currently amended):** The method as claimed in ~~one of~~ claims 1 to 3, ~~characterized in that~~ claim 1, wherein:

the longitudinal member hollow profiles ~~(2, 3, 39, 40)~~ are doubled by being bent through 180° about a horizontal axis running transversely, so that [[the]]

two resultant hollow profile strands (~~28, 29, 61, 63~~) come to lie on each other[[],];  
~~with the~~

body mountings (6, 7, 24, 42) and [[the]] bearing mountings (~~19, 43~~) of the longitudinal links [[being]] are formed on the hollow profile strand (~~28, 61~~) situated on top[[],]; and [[the]]

bent edges (30, 46) forming form the ends of the longitudinal members of the frame [(1)].

**Claim 5 (currently amended):** The method as claimed in claim 4,  
~~characterized in that; wherein:~~

before [[the]] bending ~~in that region~~ of the longitudinal member hollow profile, (~~2, 3, 39, 40~~) ~~which is indirectly adjacent to the bent edge (30, 46),~~ depressions (~~33, 34~~) are introduced into the longitudinal member hollow profile (~~2, 3, 39, 40~~) mechanically by [[means]] one of a punch [[or by]] and internal high pressure forming thereof, ~~into which depressions and~~ the respective cross member hollow profile (4, 41) is placed into said depressions; and[[],]

after the bending operation, the respective cross member hollow profile is extensively enclosed.

**Claim 6 (currently amended):** The method as claimed in claim 4,  
~~characterized in that, before the wherein:~~

before bending in the region of the longitudinal member, in which the crossbars (5, 15) are arranged, depressions (~~31, 32~~) are introduced into the longitudinal member hollow profile (~~2, 3, 39, 40~~), ~~into which depressions, and~~ the respective crossbar (5, 15) is placed into said depressions; and[[],]

after the bending operation, the cross bar is extensively enclosed.

**Claim 7 (currently amended):** The method as claimed in ~~one of claims 1 to 6, characterized in that claim 1, wherein:~~

the crossbar (5, 15) is formed from an oval tube, ~~with, first of all, the~~; a central region [(67)] of at least one longitudinal side [(9)] of the oval tube ~~being~~ ~~is~~ pressed in by means of a punch until [[the]] ~~its~~ longitudinal sides (9, 10) come to bear against each other, ~~after which the end;~~ ~~thereafter,~~ side cavities (11, 12) which arise are expanded by ~~means of applying~~ internal high pressure, with the longitudinal sides (9, 10) continuing to bear against each other, to form tubes [(68)] which run parallel and have an approximately circular cross section; and [[then,]]

in [[the]] a central region [(67)] of the longitudinal sides (9, 10), the rear axle mountings [(14)], the holes [(16)] of the securing mountings for the differential and the securing holes [(8)] for securing the transmission are punched out or produced by metal-cutting.

**Claim 8 (currently amended):** The method as claimed in ~~either of claims 5 and 6, characterized in that, after the encircling of Claim 5, wherein:~~

the cross member hollow profiles (4, 41) and the crossbars (5, 15) by the ~~operation of~~ ~~are encircled by~~ bending the longitudinal member hollow profiles (2, 3, 39, 40) through 180°; ~~and after the securing of the~~

resultantly formed longitudinal member hollow profile strands (28, 29, 61, 62) ~~are secured on one another[.]; and~~

~~thereafter,~~ at least one of the latter is expanded by ~~means of applying~~ internal high pressure until ~~a nonreleasable press fit~~ of the cross member hollow profiles (4, 41) and [[of ]]the crossbars (5, 15) in [[the]] leadthroughs formed by the depressions (31, 32, 33, 34) of the longitudinal member hollow profiles (2, 3, 39, 40) ~~arises~~ ~~are nonreleasably press fitted together.~~

**Claim 9 (currently amended):** The method as claimed in claim 8, characterized in that wherein, during [[the]] expansion of the longitudinal member hollow profile strands (28, 29, 61, 63), one of the cross members (4, 41) and/or and the crossbars (5, 15) of hollow design are acted upon from [[the]] inside with a deformation-preventing, fluidic counterpressure.

**Claim 10 (currently amended):** The method as claimed in either of claims 5 and 6, characterized in that claim 5, wherein one of the cross members (4, 41) and/or and the crossbars (5, 15) of hollow design are expanded [[with]] by a fluidic high pressure at [[the]] a location of [[the]] leadthroughs formed by the depressions (31, 32, 33, 34) of the longitudinal member hollow profiles (2, 3, 39, 40).

**Claim 11 (currently amended):** The method as claimed in claim 10, characterized in that wherein, during [[the]] expansion of one of the cross members (4, 41) and/or and of the crossbars (5, 15), the two hollow profile strands (28, 29, 61, 63) of the longitudinal member hollow profiles (2, 3, 39, 40) are acted upon with a deformation-preventing, fluidic counterpressure.

**Claim 12 (currently amended):** The method as claimed in one of claims 1 to 11, characterized in that claim 1, wherein, in the case of a two-part design of the frame [(1)] with a division between the crossbars (5, 15), the mutually facing ends (18, 45, 66) of the longitudinal member hollow profiles (2, 3, 39, 40) are inserted one inside another and are subsequently connected nonreleasably to one another.

**Claim 13 (currently amended):** The method as claimed in claim 12, characterized in that the ends (18, 45, 66) wherein one of the following is true:

ends which are inserted one inside another are welded to one another [[or,]]; and

after forming at least one form-fitting element at [[the]] an end (45, 66) receiving the end [[(18)]] to be inserted by means of internal high pressure with a shape-negative mating form-fitting element being formed, are fixed in a form-fitting manner at the location of the form-fitting element.

**Claim 14 (currently amended):** The method as claimed in ~~one of claims 1 to 13, characterized in that the claim 1, wherein:~~

~~a spring strut mounting [[(44)]] of the frame [[(1)]] is formed from the longitudinal member hollow profile; (39, 40), with~~

~~the latter being longitudinal member hollow profile is bent upward by an angle of at least 90° on a section [[(50)]] at a location about a horizontal axis [[(52)]], which intersects the central longitudinal axis [[(51)]] of the hollow profile (39, 40) at an angle of approximately 45°, such that the hollow profile (39, 40) protrudes laterally [[there]], with regard to its essentially rectilinear directional profile, outside the spring strut mounting; (44), after which the and~~

~~thereafter, lateral excess length is angled in order to form the spring strut mounting (44) after a certain with a preset height offset with respect relative to the hollow profile (39, 40) running outside the spring strut mounting [[(44)]].~~

**Claim 15 (currently amended):** The method as claimed in claim 14, ~~characterized in that wherein:~~

~~the longitudinal member hollow profile (39, 40) is formed from two separate contiguous individual hollow profiles; arranged in a row next to each other, with one~~

~~a first half of the spring strut mounting (44) being is formed by [[the]] bending and angling [[of]] one end of the one individual hollow profile, and with, adjoining this one half of the spring strut mounting (44), in order to form;~~

the other half of the spring strut mounting (44), the is formed by bending a facing end of the other individual hollow profile being is bent us in a mirror-inverted manner with respect to [[this]] the first half, and [[being]] is angled in the same direction[[,]]; and

thereafter after which the two halves are connected fixedly to each other.

**Claim 16 (currently amended):** The method as claimed in claim 14,  
wherein: characterized in that the

each longitudinal member hollow profile (39, 40) is composed of in each ease two contiguous separate hollow profile strands (61) and (63) lying on each other, in that the one;

a first half of the spring strut mounting [[(44)]] is formed from [[an]] a first end [[(62)]] of the hollow profile strand [[(61)]] that is in the vicinity of the cross member; [[and]]

the other half of the spring strut mounting [[(44)]] is formed from [[an]] a second end [[(64)]], which tapers to [[this]] the first end [[(62)]], of the longer hollow profile strand, (63) which runs essentially downward and is bent back on itself through 180°, in that;

the [[two]] first and second ends (62, 64) are angled about an axis parallel to the longitudinal axis of [[that]] a part of the longitudinal member hollow profile (39, 40) which does not belong to the spring strut mounting [[(44)]] and is situated next to it[[,]]; and in that,

after they are flattened at their point of abutment, the first and second ends (62, 64) bearing against each other are connected nonreleasably, preferably welded.

**Claim 17 (currently amended):** The method as claimed in claim 14,  
characterized in that

the spring strut mounting [[(44)]] of the frame [[(1)]] is formed as a single piece from the longitudinal member hollow profile, which is (39, 40), ~~with the longitudinal member hollow profile (39, 40) being bent back at both ends through 180°[.,]~~ and ~~in that its ends~~

extremities of the longitudinal member hollow profile subsequently are bent in a mirror-inverted manner with respect to one another about the horizontal axis [[(52).]];

~~with in each case one half of [[the]] each spring strut mounting (44) being is formed, and [[are]] angled in the same direction, after which; and~~

thereafter, the halves bearing laterally against each other are connected fixedly to each other.

**Claim 18 (currently amended):** The method as claimed in claim 14, characterized in that the wherein:

a radially protruding section [[(50)]] is bent forward through approximately 90°; [[.-]] parallel to [[the]] a longitudinal direction of the longitudinal member hollow profile, (39, 40) [[.-]] about a further parallel axis [[(53)]] spaced apart vertically from the horizontal axis [[(52)]], so that a subsection [[(54)]] of the radially protruding section [[(50)]] lies approximately parallel to [[the]] a longitudinal extent of the remaining longitudinal member hollow profile (39, 40) adjoining the spring strut mounting [[(44)]], but with a height and lateral offset thereto, with the one half of the spring strut mounting [[(44)]] extending as far as the center of the subsection [[(54).]]; and ~~in that the~~

production of the other half of the spring strut mounting [[(44)]], which half runs from the center of the subsection [[(54)[[ in the direction of [[the]] a front cross member [[(41)]]], takes place by mirror-inverted further bending of the section [[(50)]] following the subsection [[(54)]].

**Claim 19 (currently amended):** The method as claimed in ~~one of claims 14 to 18, characterized in that claim 18, wherein~~ the lateral excess length is angled into a horizontal plane.

**Claim 20 (currently amended):** The method as claimed in ~~one of claims 14 to 19, characterized in that claim 19, wherein~~ the angled portion is flattened.

**Claim 21 (currently amended):** The method as claimed in claim 20, ~~characterized in that wherein~~ the flattened portion is perforated.

**Claim 22 (currently amended):** The method as claimed in either of claims 20 and 21, ~~characterized in that claim 21, wherein~~ the flattened portion [[(65)]] of the ends (62, 64) is bent downward at a right angle on the end side.

**Claim 23 (currently amended):** The method as claimed in ~~one of claims 14 to 22, characterized in that, claim 22, wherein:~~

after [[the]] bending of the longitudinal member hollow profile (39, 40) to form the spring strut mounting [[(44)]], the latter spring strut mounting is acted upon at both ends by internal high pressure[[, with]]; the cross section of the longitudinal member hollow profile, which is severely crushed during the bending[[.]] of its two struts, producing (58, 59), which produce the height offset with respect to the remaining longitudinal member hollow profile, is (39, 40), being expanded to form a circular cross section in rough approximation.

**Claim 24 (currently amended):** The method as claimed in ~~one of claims 1 to 23, characterized in that claim 23, wherein~~ form-fitting elements in the form of depressions, ~~preferably channels~~ (38), are formed on [[the]] upper sides of the longitudinal member hollow profiles (39, 40) by means of a punch.

**Claim 25 (currently amended):** The method as claimed in claim 24, ~~characterized in that wherein~~ mating form-fitting elements, ~~preferably ribs~~ (37) from the depression-free hollow profile strand, are formed in the form-fitting

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elements by ~~means of~~ internal high pressure forming, after [[the]] bending to double the respective longitudinal member hollow profile (39, 40).